

**Work Order ID 78673**

January-12-12 10:53:21 AM

**\*78673\***

Page 1

Item ID: D206-667-247TRN

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Crosstube Assembly, Mid Aft

Stop **\*NS2\***

Start Date: 12/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: M.C.JDate: 12/01/12 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D206-667-247

A

100

0.00

**\*100\***

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand &amp; install plugs DTxxxx on both ends as per Folio FB030

2-Turn first side as per Folio FB030

3-File down transition lines smooth.

FOLIO REV: ADWG REV: A1 Ø  
M.C.J 12/01/17

110

QC1- Inspect dimensions to dimension sheet

0.00

**\*110\***

QC

Memo

0.00

Quality Control

1 Ø  
M.C.J 12/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Start Date: 12/01/2012 Start Qty: 1.00

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**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
<b>*120*</b>	MORI SEIKI CNC LATHE LARGE								
Mori Seiki	<b>Memo</b>	0.00							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FB030 2-File down transition lines smooth. 3-Remove sand and plugs FOLIO REV: <u>AA</u> DWG REV: <u>A</u>								
130	QC1- Inspect dimensions to dimension sheet	0.00							
<b>*130*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00							
<b>*140*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

MML 12/01/17

MML 12/01/17

DP 12-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 78673

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Page 3

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Item ID: D206-667-247TRN

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Crosstube Assembly, Mid Aft.

Stop **\*NS2\***

Start Date: 12/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

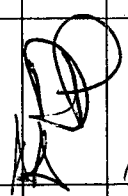


Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145		0.00							
<b>*145*</b>									
Crosstubes	Memo	0.00							
Crosstubes	GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.		N/A						
150	Crosstubes Chemical Conversion	0.00							
<b>*150*</b>									
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes									
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

① ~~CE/NO~~ 12-1-20

DD 12-1-23 PTO

W/O: 78673		Rem Chg						WORK ORDER CHANGES			
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
12-1-23	160	Should read QC7		12-1-23 12.01.24							

Part No: D206667-247TRJ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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Page 4

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Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Crosstube Assembly, Mid Aft

Start Date: 12/01/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Packaging	0.00							
*170*									
Packaging	Memo	0.00							
Packaging	Identify and stock in kanban rack Location: <u>46</u>								
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

DP 12-1-23

12/1/24

12/01-24

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

January-12-12 10:53:24 AM

Page 1

Work Order ID: 78673

**\*78673\***

Parent Item: D206-667-247TRN

**\*D206-667-247TRN\***

Parent Item Name: Crosstube Assembly, Mid Aft

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 11.01.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6004-115		Manufactured	No			100	Each	16.0000	1	1			

**\*D6004-115\***

Crosstube Material

**\*\***

Location

Loc Qty

Loc Code

LG

16

34685

5

38336

11

mm.L 12/01/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 78673
<b>Description:</b> Crosstube Assembly, Mid Aft	<b>Part Number:</b> D206-667-247TRN
<b>Inspection Dwg:</b> D206-667-247 Rev: A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.491	/		vern	CNC-OK
	2.025	+0.005/-0.000	2.026	/			
	2.079	+0.005/-0.000	2.082	/			
	2.145	+0.005/-0.000	2.149	/			
	2.209	+0.005/-0.000	2.214	/			
	2.287	+0.005/-0.000	2.290	/			
	2.363	+0.005/-0.000	2.368	/		↓	
	0.200	+/-0.010	.200	/		vern	CNC-OK
	R0.063	+/-0.010	.063	/		RG	
	R2.00	+/-0.010	2.00	/		↓	
	R0.063	+/-0.010	.063	/		↓	
	<del>4.500</del>	+/-0.010	4.440	/		vern	CNC-OK
	4.438						
SIDE B	2.490	+0.005/-0.000	2.491	/		vern	CNC-OK
	2.025	+0.005/-0.000	2.026	/			
	2.079	+0.005/-0.000	2.082	/			
	2.145	+0.005/-0.000	2.150	/			
	2.209	+0.005/-0.000	2.214	/			
	2.287	+0.005/-0.000	2.290	/			
	2.363	+0.005/-0.000	2.366	/		↓	
	0.200	+/-0.010	.200	/		vern	CNC-OK
	R0.063	+/-0.010	.063	/		RG	
	R2.00	+/-0.010	2.00	/		↓	
	R0.063	+/-0.010	.063	/		↓	
	<del>4.500</del>	+/-0.010	4.440	/		vern	CNC-OK
	4.438						
	99.76	+/-0.020	99.760	/		tape	mm. L-02

<b>Measured by:</b> M.M.C.	<b>Audited by:</b> D.D.	<b>Preliminary Approval:</b>
<b>Date:</b> 12/01/16	<b>Date:</b> 12-1-19	<b>Date:</b>
<b>Rev</b> A	<b>Date</b> 11.06.21	<b>Change</b> New Issue
<b>Revised by</b> KJ	<b>Approved</b>	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Item	Qty	Part Number	Description
	-247		
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 99.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON INSIDE OF CLIFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

UNCONTROLLED COPY

SUBJECT TO CHANGE

WITHDRAWN

WORK ORDER

NO. 78673 4.6.0  
12/01/12

DEO ATTACHED

OCW #11-615

11.07.28

UNDER REVIEW

RELEASED  
2011-05-24

A	NEW ISSUE	CP	10.12.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D206-667-247	REV. A SHEET 1 OF 4
TITLE CROSSTUBE ASSY (206L MID AFT)	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

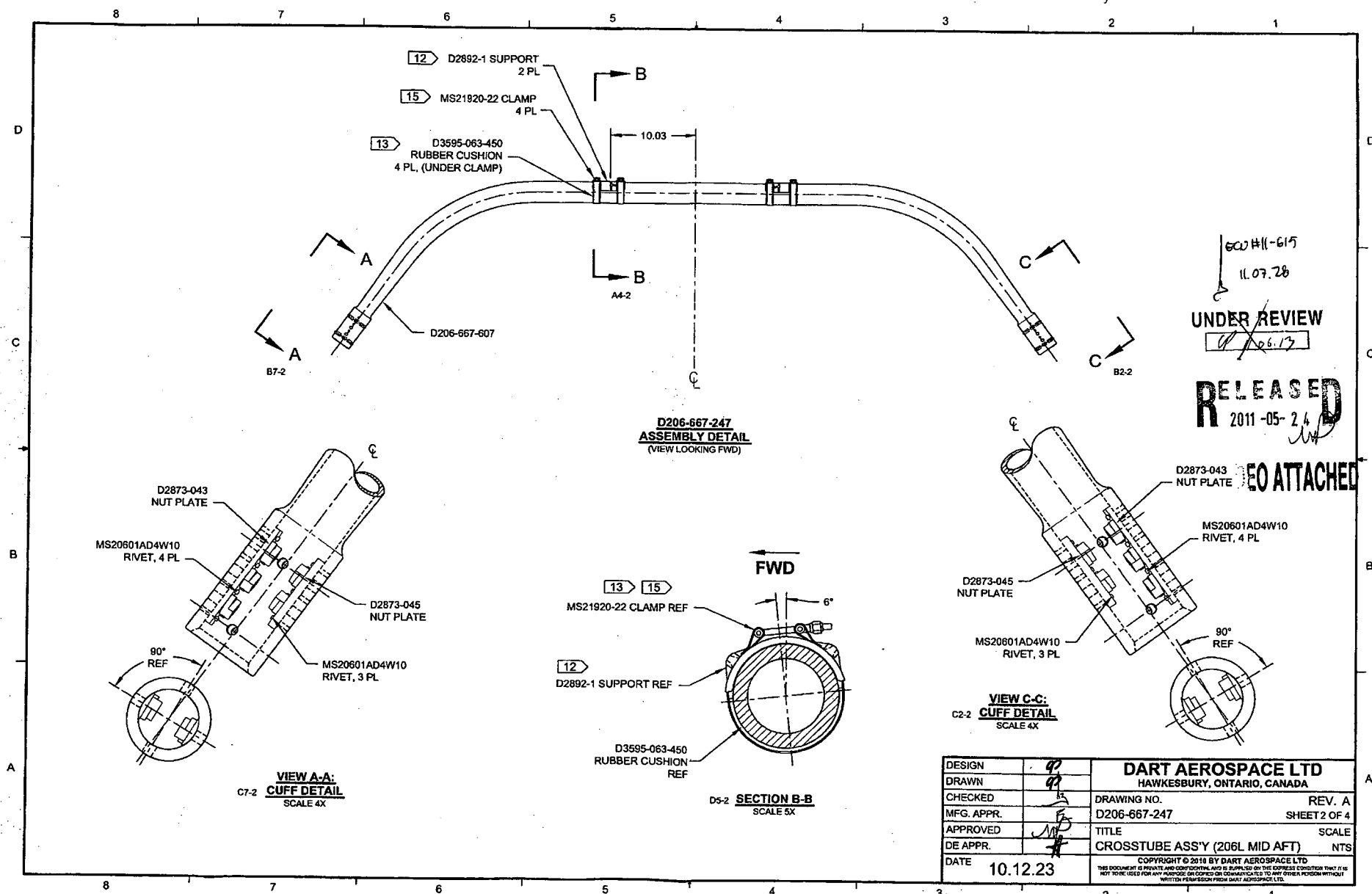
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

72673



DESIGN	72673	DART AEROSPACE LTD	
DRAWN	72673	HAWKESBURY, ONTARIO, CANADA	
CHECKED	72673	DRAWING NO.	REV. A
MFG. APPR.	72673	D206-667-247	SHEET 2 OF 4
APPROVED	72673	TITLE	SCALE
DE APPR.	72673	CROSSTUBE ASSY (206L MID AFT)	NTS
DATE	10.12.23	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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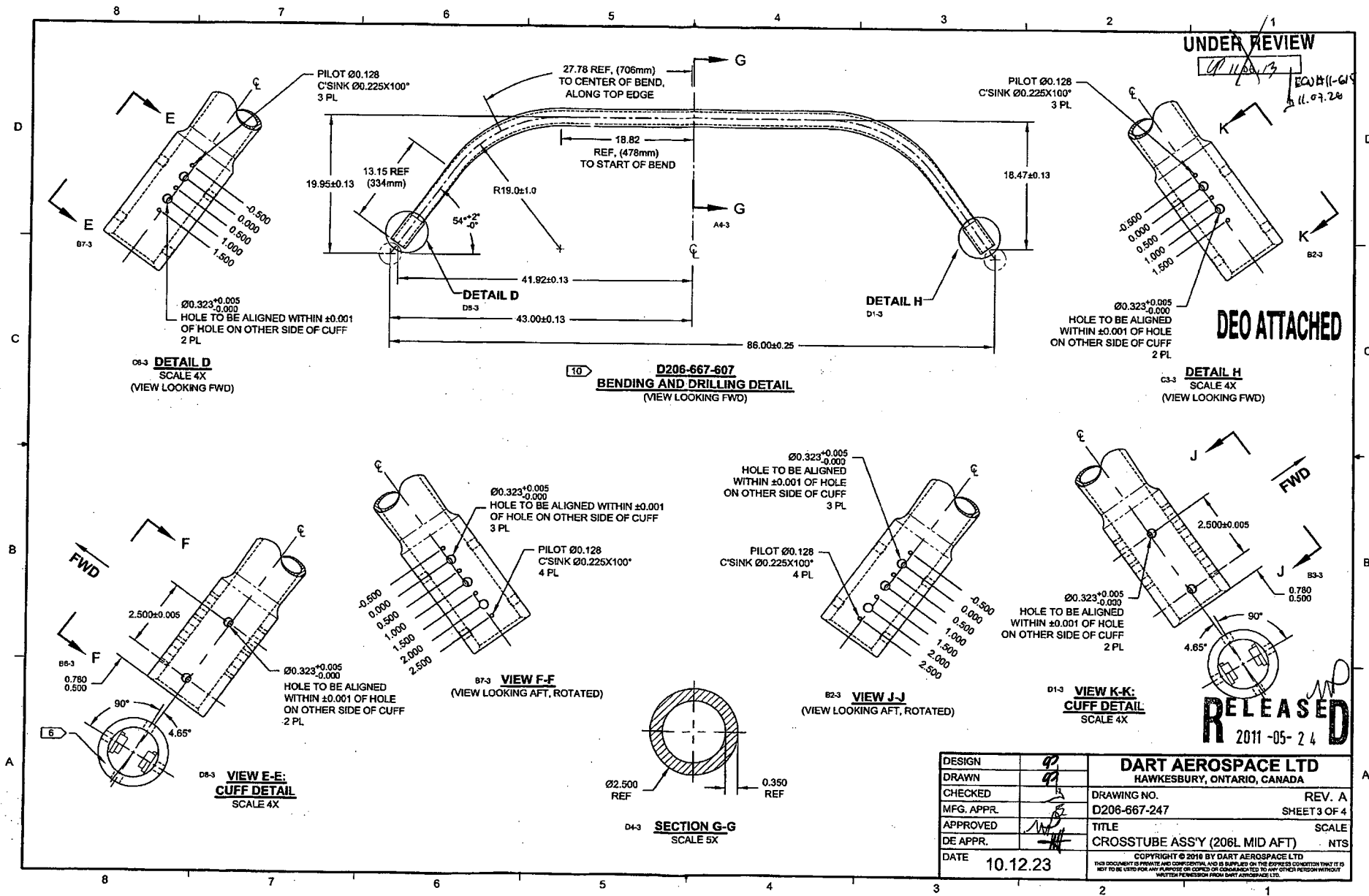
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**NOTE:** Date & initial all entries



78673



DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D206-667-247	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSY (206L MID AFT)	NTS
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

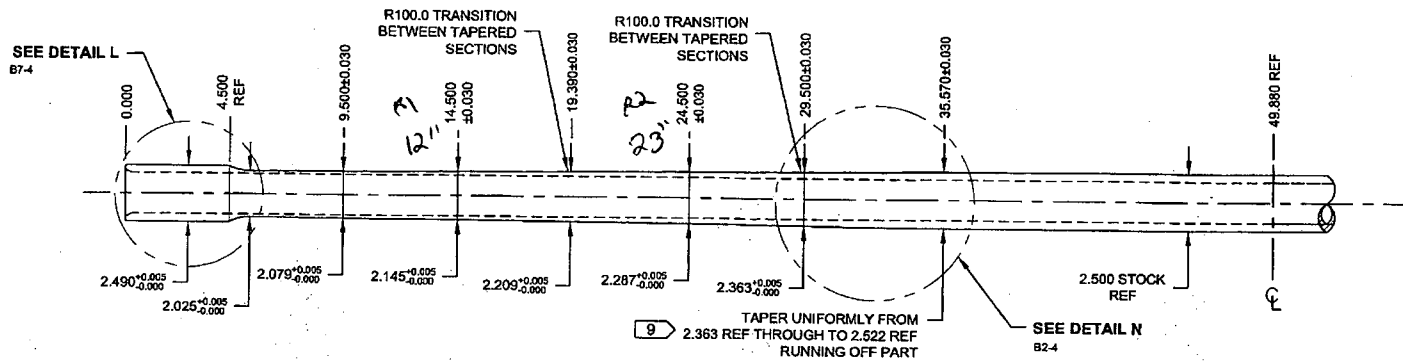
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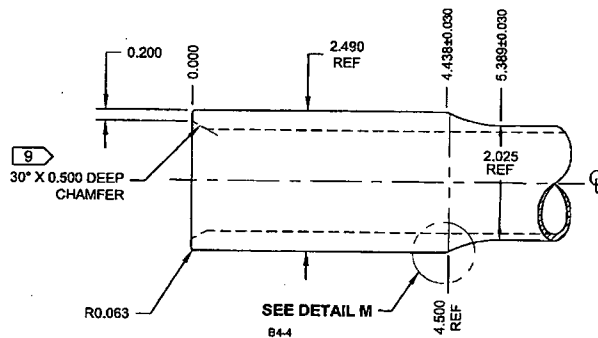
NOTE: Date & initial all entries

side A		side B	
A1	1- .168	A1	1- .166
	2- .161		2- .166
	3- .160		3- .166
	4- .164		4- .174
A2	1- .243	A2	1- .244
	2- .234		2- .238
	3- .232		3- .233
	4- .237		4- .239

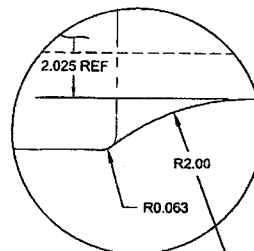
70673



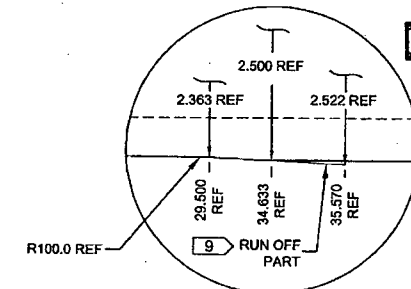
**TURNING DETAIL**



**DETAIL L: CROSSTUBE CUFF**  
SCALE 2.5X



**DETAIL M: CUFF TRANSITION**  
NOT TO SCALE



**DETAIL N: TAPER RUN-OFF**  
NOT TO SCALE

BCN #11-615  
11.07.28  
**UNDER REVIEW**  
P 1.06.13

**DEO ATTACHED**

**RELEASED**  
2011-05-26

DESIGN	9	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	9		
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	9	D206-667-247	SHEET 4 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASSY (206L MID AFT)	NTS
DATE	10.12.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78673

DRAWING NO. D206-667-247	TITLE CROSSTUBE ASS'Y (206L MID AFT)	REV. A	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D206-667-247-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN qp	CHECKED ASS	MFG. APPR. KDD	APPROVED JMD		DE APPR. H		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

**PURPOSE:**

REPLACE MAGNOBOND WITH PROSEAL.

**CHANGE:**

IS:

Item	Qty -247	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 &amp; 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED  
2011-07-28  
JMD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries